

Work Order ID 109504

November-21-13 2:33:08 PM

109504

Page 1

Item ID: D412-776-011

Revision ID:

Item Name: Glareshield

Start Date: 11/21/13 Start Qty: 1.00 ***1***

Required Date: 11/21/13 Req'd Qty: 1.00 ***1***

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 13-11-22

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-776	Rev B

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D412-776-011

CHG001

0.00

0.00

APR - 4 2014

DAS
31
9-89

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

DAS
32
9-89

14/4/2 (1)

DAS
31
9-89

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

APR - 4 2014

DAS
31
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-776-011 Location: 049 PPP Rev:

0.00

0.00

APR - 4 2014

DAS
06
9-89

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

14/04/94

14-04-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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November-21-13 2:33:07 PM

Parent Item Name: Glareshield

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08.05-12 new issue DD verified by: LL
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-3A Bolt		Purchased	No			120	Each	399.0000	6	6		DAS 32 9-89	DAS
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		399							
				123831		7							
				124552		1							
				m126192		1							
				m126249		190							
				m127044		200							
AN3-5A Bolt		Purchased	No			120	Each	1,480.0000	10	10		DAS 32 9-89	DAS
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		12							
				122800		12							
				GA		120							
				117423		120							
				ST350		22							
				120187		22							
				ST511		1000							
				m126559		1000							
				ST512		326							
				122416		19							
				124561		307							
AN970-3 Washers		Purchased	No			120	Each	241.0000	4	4		DAS 32 9-89	DAS
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST343		241							
				121163		12							
				125445		54							
				m127432		175							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

November-21-13 2:33:07 PM

Page 2

Work Order ID: 109504

Parent Item: D412-776-011

Parent Item Name: Glareshield

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

D3690-041
Glareshield Assembly

DAS
31

Manufactured No

120 Each 0.0000

1 1 109379

D3699-041
Support Assembly

9-89

Manufactured No

120 Each 7.0000

1 1 DAS
32
9-89

DAS
31
9-89

Location
ST248A

Loc Qty
7
7

Loc Code

84076

84076
1 1

D3699-042
Support Assembly

DAS
31
9-89

Manufactured No

120 Each 5.0000

1 1 DAS
32
9-89

Location
ST247A

Loc Qty
5
5

Loc Code

84846

84846
12 12

MS20426AD3-3
RIVET

DAS
31
9-89

Purchased No

120 Each 3,811.0000

12 12 DAS
32
9-89

Location
ST316

Loc Qty
699
282

Loc Code

119109
19099

ST334

3112
29
120
2963

121011
122814
123352

m/23352

MS21042L06
Nut

DAS
31
9-89

Purchased No

120 Each 305.0000

11 11 m/27837 DAS
32
9-89

Location
ST314

Loc Qty
305
16

Loc Code

124859
m126474
m127304

153
136

14/4/2 (1)

November-21-13 2:33:07 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 109504
Parent Item: D412-776-011
Parent Item Name: Glareshield

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 1.00

Required Qty: 1.00

MS21075L08

Purchased No

120 Each 64.0000

6

6

9-89

ANCHOR NUT

DAS
31
9-89

Location

Loc Qty

Loc Code

ST318

64

M126145

64

MS35206-228

Purchased No

120 Each 296.0000

11

11

DAS
32
9-89

SCREW

DAS
31
9-89

Location

Loc Qty

Loc Code

ST288

296

120560

296

NAS1149D0332J

Purchased No

120 Each 2,830.0000

12

12

DAS
32
9-89

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST293

1524

125268

7

m127374

520

m127431

997

ST294

306

122973

75

125044

8

m125807

223

ST511

1000

m127389

1000

NAS1149DN616J

Purchased No

120 Each 40.0000

11

11

DAS
32
9-89

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST293

40

119438

40

14/4/2 (1)

November-21-13 2:33:07 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



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APR 1 2014

REFERENCE ONLY

DAS
31
9-89**4. WEIGHT AND BALANCE**

The net weight increase associated with the D412-776-011 Replacement Glareshield Kit is negligible.

5. PARTS LIST

Qty -011	Part Number	Description
X	D412-776-011	REPLACEMENT GLARESHIELD KIT
1	D3690-041	GLARESHIELD ASSEMBLY
1	D3699-041	SUPPORT ASSEMBLY
1	D3699-042	SUPPORT ASSEMBLY
6	AN3-3A	BOLT
10	AN3-5A	BOLT
12	AN960JD10L	WASHER (or NAS1149DN332J)
11	AN960JD6L	WASHER (or NAS1149DN616J)
4	AN970-3	WASHER
12	MS20426AD3-3	RIVET
11	MS21042L06	NUT
6	MS21075L08	ANCHOR NUT
11	MS35206-228	SCREW

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Revision: **B**
Date: 08.06.24

